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MAY 02 2018

003097

D044-662-011
Job Sheet 176819



Part No: D044-662-011

Job Qty: 3 ea

Part Name: R44 Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/30/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	3 Ea	5/30/18	5/30/18	0.00	0.00	Start Up Stores/Pkg-1		
105	Packaging	3 pcs	5/30/18	5/30/18	0.00	0.00	Packaging1-1		
110	QC	3 pcs	5/30/18	5/30/18	0.00	0.00	QC4		
115	DC	3 pcs	5/30/18	5/30/18	0.00	0.00	DC		
120	Packaging	3 pcs	5/30/18	5/30/18	0.00	0.00	Packaging3-1		
130	QC21-FG	3 Ea	5/30/18	5/30/18	0.00	0.00	QC21		

Part Op 115 - Photocopy bluefile & type labels per PPPD044-662-011 CHG004

Descriptions: 120 - Identify and pack for shipping as per PPP D044-662-011 LOCATION: FG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	12 Ea (4 ea)	90-Start up Operation	5062375
AN4-15A	Bolt	12 Ea (4 ea)	90-Start up Operation	5057424
D2529	Washer	24 Ea (8 ea)	90-Start up Operation	5060394x20 5035698x4
D3075-1	Bearpaw (Foot Print Only)	6 Ea (2 ea)	90-Start up Operation	5067124x0 5067592x5
D3556-1	R44 Bearpaw Clamp	12 Ea (4 ea)	90-Start up Operation	50845330
D3601-1	Radius Block	24 Ea (8 ea)	90-Start up Operation	5067124x0 5054526x4
D4953-1	Cushion	12 Ea (4 ea)	90-Start up Operation	5053229
MS21042L4	Nut	24 Ea (8 ea)	90-Start up Operation	5056039
NAS1149D0463J	Washer	24 Ea (8 ea)	90-Start up Operation	5055952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	12	482	0
	AN4-15A	12	439	0
	D2529	24	2,189	0
	D3075-1	6	8	0
	D3556-1	12	28	0
	D3601-1	24	225	0
	D4953-1	12	292	0
	MS21042L4	24	2,862	0
	NAS1149D0463J	24	5,559	0



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Container No: S085217



Part: D044-662-011

Job No: 176819

Serial No/Batch: S085217

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/28/18

Part Specifications

Specifications could not be found.

Plex 5/2/18 9:46 AM dart.quirion.sonia

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)

PAGE 1 OF 1

Description: BEARPAW INSTALLATION

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							